

Work Order ID 148105

June 24, 2016 11:50:13 AM

148105

Ship July 5

or sooner. Page 1

Item ID: D206-802-032

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Passenger Door Opener RH

Stop *NS2*

Start Date: 6/27/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/5/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: SBA Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI9579	B
IIN D206-802-3	A

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D206-802-032 CHG004

SBA 6/24/16

105

Pick Kit

0.00

105

Packaging

Memo

0.00

Packaging

JUN 27 2016

DAS
27
DAS 9-89
6
8-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Désign ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 148105

June 24, 2016 11:50:13 AM

148105

Page 2

Item ID: D206-802-032

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Passenger Door Opener RH

Stop

NS2

Start Date: 6/27/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/5/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

DAS

28

9-89

120

Packaging

0.00

120

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPDD206-802-032

Location: _____

PPP rev: _____

PPP 148101

JUL 05 2016

DAS

DAS

28

27

9-89

9-89

JUL 05 2016

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

DAS

21

9-89

JUL 05 2016

16/7/6 J

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause			FAULT CATEGORY					
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong			
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions			
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance			
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect			
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing			
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved			
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing			
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish			
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread			
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence			
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____						
Misidentified ☐	☐ Past Due							

Picklist Print

June 24, 2016 11:50:18 AM

Page 1

Work Order ID: 148105

148105

Parent Item: D206-802-032

D206-802-032

Parent Item Name: Passenger Door Opener RH

Start Date: 6/27/2016

Required Date: 7/5/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.12.03 as per dwg rev.A DD verf:EC IPP Rev:B
11.10.25 AS PER DSI9579 REV.A DD verf:EC IPP Rev:C 11.12.19
PER DSI9579 REV B DD verf:EC IPP Rev:D 12.07.30 AS PER
ECN12-624 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3552-17		Manufactured	No			105	Each	3.0000	1	1		DAS 6 9-89	DAS 27 9-89
D3552-17									**				
Door Prop													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST363				3					
				126847				3					
D3622-5		Manufactured	No			105	Each	8.0000	2	2		DAS 6 9-89	DAS 27 9-89
D3622-5									**				
Ball Stud													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST046				8					
				129766				4					
				133920				4					
D4112-1		Manufactured	No			105	Each	1.0000	1	1		DAS 6 9-89	DAS 27 9-89
D4112-1									**				
Aft Sill Doubler													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST084				1					
				130062				1					
D4115-5		Manufactured	No			105	Each	1.0000	1	1		DAS 6 9-89	DAS 27 9-89
D4115-5									**				
Doubler													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST084				1					
				129975				1					

JUN 27 2016

Picklist Print

June 24, 2016 11:50:18 AM

Page 2

Work Order ID: 148105

148105

Parent Item: D206-802-032

D206-802-032

Parent Item Name: Passenger Door Opener RH

Start Date: 6/27/2016

Required Date: 7/5/2016

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4-5

Purchased

No

105

Each

1,666.000

4

4

MS20426AD4-5

RIVET

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

1316

m133751

1316

ST312

350

m133751

350

4

DAS
6
9-89

DAS
27
9-89

MS20600-AD4W2

Purchased

No

105

Each

369.0000

14

14

MS20600-AD4W2

Rivet

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

119

m126475

119

ST308

250

m134762

150

m135058

100

14

DAS
6
9-89

DAS
27
9-89

MS21073L5

Purchased

No

105

Each

59.0000

2

2

MS21073L5

Anchor Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

ST298

59

m132680

9

m135058

50

2

DAS
6
9-89

DAS
27
9-89

JUN 27 2016

Picklist Print

June 24, 2016 11:50:19 AM

Page 3

Work Order ID: 148105

148105

Parent Item: D206-802-032

D206-802-032

Parent Item Name: Passenger Door Opener RH

Start Date: 6/27/2016

Required Date: 7/5/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0532R

Purchased

No

105

Each

483.0000

6

6

NAS1149C0532R

WASHER

DAS 27
6 9-89

Location

Loc Qty

Loc Code

GA

60

116513

60

ST266

423

m133031

23

m134756

200

m135056

200

DAS
28
9-89

6

NAS1149C0563R

Purchased

No

105

Each

467.0000

6

6

NAS1149C0563R

Washer

DAS 27
6 9-89

Location

Loc Qty

Loc Code

ST265

467

m131697

467

DAS
28
9-89

6

D4108-11

Manufactured

No

105

Each

5.0000

1

1

D4108-11

Template

DAS 27
6 9-89

Location

Loc Qty

Loc Code

ST082

5

85048

5

DAS
28
9-89

1

D4108-047

Manufactured

No

105

Each

3.0000

1

1

D4108-047

Sill Doubler Assembly

DAS 27
6 9-89

Location

Loc Qty

Loc Code

ST083

3

129865

1

133849

2

DAS
28
9-89

1

JUN 27 2016

June 24, 2016 11:50:19 AM

Shop Packet Print

Page 3

Picklist Print

June 24, 2016 11:50:19 AM

Page 4

Work Order ID: 148105

148105

Parent Item: D206-802-032

D206-802-032

Parent Item Name: Passenger Door Opener RH

Start Date: 6/27/2016

Required Date: 7/5/2016

Start Qty: 1.00

Required Qty: 1.00

CR3523-4-4

Purchased

No

105

Each

194.0000

4

4

CR3523-4-4

Rivet

DAS

27

9-89

DAS

6

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK004

100

m127255

100

ST318

94

124259

84

m130388

10

D3552-27

Manufactured

No

105

Each

2.0000

1

1

D3552-27

Door Prop

DAS

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

Mezz

2

89499

2

DAS

6

9-89

JUN 27 2016

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-802-3 Rev. A AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D407-802 REV. 0

REF CANADIAN STC: SH10-44

REF FAA STC: SR02933NY

REF EASA STC: 10033253

1.0 PURPOSE:

It has come to Dart's attention that a portion of the airframe on recent Bell 206L4 aircraft is made of composite. In such cases, installing the D4112-1 (ref. D206-802-032 Kit) per IIN-D206-802-3 might not be possible. To that effect, Dart has created DSI 9579-011 Upgrade Kit to facilitate installation of D206-802-032 Kits at Change 001. The parts list of D206-802-032 Kits at Change 002 and later is amended as follows:

2.0 PARTS LIST CHANGE:

5.2 D206-802-031/-032 Passenger Door Opener Kits (IIN-D206-802-3 Rev. A)

52.4.9 D206-802-031/-032 Passenger Door Opener Kits (ICA-D407-802 Rev. 0)

Qty -031	Qty -032	Part Number	Description
1		D206-802-031	PASSENGER DOOR OPENER KIT, LH
	1	D206-802-032	PASSENGER DOOR OPENER KIT, RH

ADD:

	1	D4108-11	TEMPLATE
	1	D4108-047	SILL DOUBLER ASSEMBLY
	4	CR3523-4-4	RIVET
	1	D3552-27	DOOR PROP

3.0 DSI-9579-011 UPGRADE KIT PARTS LIST:

Qty -011	Part Number	Description
1	DSI 9579-011	UPGRADE KIT
1	D4108-11	TEMPLATE
1	D4108-047	SILL DOUBLER ASSEMBLY
4	CR3523-4-4	RIVET
1	D3552-27	DOOR PROP

SLA
148105
6/24/16

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 11.12.07

CERT. NO.: SH10-44

ISSUE NO.: 1

B	ADD DOOR PROP D3552-27	AP	11.12.07
A	NEW ISSUE	MB	11.10.14
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9579	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		UPGRADE KIT	NTS
DATE	11.12.07	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

4.0 INSTALLATION CHANGE:

4.1 On metal airframe:

No change. Install D206-802-032 using D4112-1 per Section 3.3 of IIN-D206-802-3.

4.2 On composite airframe:

Install D206-802-032 by replacing D4112-1 Aft Sill Doubler with D4108-047 per instructions below and Figure 1 of this Service Instruction.

4.2.1 Perform Step 3.3.1 of IIN-D206-802-3.

4.2.2 Replace Steps 3.3.2 to 3.3.16 with the following:

- a) Using Figure 1 of this Service Instruction, locate D4108-11 Template on the edge of the door post closeout approximately 17.5" from the front of the seat. Match drill the $\varnothing 0.128$ " rivet holes (4 PL) on the door sill. Locate and drill thru template and door sill if the door sill is without existing holes.
- b) Transfer drill the $\varnothing 0.128$ " holes (4 PL) from D4108-11 Template to the D4108-047 Sill Bracket Assembly.
- c) Deburr all drilled holes and clean area.
- d) Remove and retain the Ball Stud and hardware from the D4108-047 Sill Bracket Assembly.
- e) Install D4108-047 Sill Bracket Assembly by applying a thin layer of Proseal 890 and wet installing the CR3523-4-4 Rivets (4 PL) as shown in Figure 1 of this Service Instruction.
- f) Remove excess Proseal, grind rivet stems flush and clean area of any debris.
- g) Re-install the Ball Stud and hardware removed at Step "d)" of this instruction.
- h) Re-position the carpet and interior trim panel. Trim/cut as required for the ball stud and to allow the D4108-047 Sill Bracket Assembly to protrude.
- i) Re-install the scuff plate.
- j) Install rod end of D3552-27 Door Prop onto the Ball Stud mounted on D4108-047 Sill Bracket Assembly.
- k) With the door open and using the D3552-27 Door Prop, Figure 4 and the dimensions shown as reference, position D4115-5 Doubler. Ensure that the door opens far enough for ingress and egress (minimum of 19" wide) and that there is no interference with any structure or interior trims. The final location of the D4115-5 Doubler will vary somewhat from aircraft to aircraft.

4.2.3 Perform Steps 3.3.17 to 3.3.26 of Installation Instructions IIN-D206-802-3.

4.2.4 Replace Step 3.3.27 with the following:

- a) Attach the cylinder end of the D3552-27 Door Prop to the D3622-5 Ball Stud installed on the previous step.

4.2.5 Complete installation of D206-802-032 by following Steps 3.3.28 to 3.3.29 of Installation Instructions IIN-D206-802-3.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:

D. SHEPHERD (DE # 02)

DATE: 11.12.07

CERT. NO.: SH10-44

ISSUE NO.: 1

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UP	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9579	SHEET 2 OF 3
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	UPGRADE KIT	NTS
DATE 11.12.07		COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

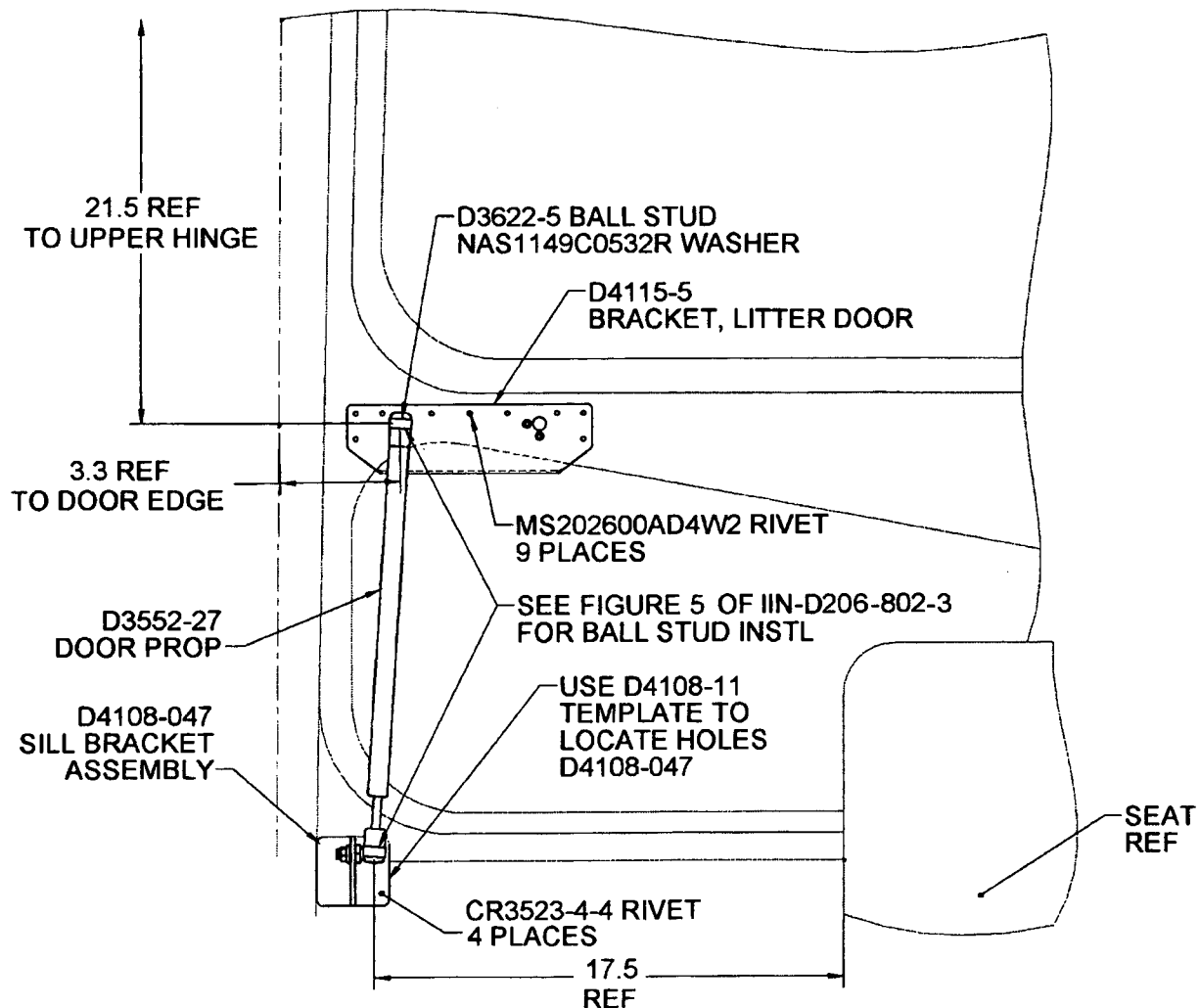


FIGURE 1: INSTALLATION OF D206-802-032 ON COMPOSITE AIRFRAME

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 11.12.07
CERT. NO.: SH10-44
ISSUE NO.: 1

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	<u>[Signature]</u>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9579	SHEET 3 OF 3
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	UPGRADE KIT	NTS
DATE	11.12.07	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-802-3 Rev. A AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D407-802 REV. 0

REF CANADIAN STC: SH10-44

REF FAA STC: SR02933NY

REF EASA STC: 10033253

DAS
28
9-89

1.0 PURPOSE:

It has come to Dart's attention that a portion of the airframe on recent Bell 206L4 aircraft is made of composite. In such cases, installing the D4112-1 (ref. D206-802-032 Kit) per IIN-D206-802-3 might not be possible. To that effect, Dart has created DSI 9579-011 Upgrade Kit to facilitate installation of D206-802-032 Kits at Change 001. The parts list of D206-802-032 Kits at Change 002 and later is amended as follows:

2.0 PARTS LIST CHANGE:

5.2 D206-802-031/-032 Passenger Door Opener Kits (IIN-D206-802-3 Rev. A)

52.4.9 D206-802-031/-032 Passenger Door Opener Kits (ICA-D407-802 Rev. 0)

Qty -031	Qty -032	Part Number	Description
		D206-802-031	PASSENGER DOOR OPENER KIT, LH
		D206-802-032	PASSENGER DOOR OPENER KIT, RH

ADD:

	1	D4108-11	TEMPLATE
	1	D4108-047	SILL DOUBLER ASSEMBLY
	4	CR3523-4-4	RIVET
	1	D3552-27	DOOR PROP

3.0 DSI-9579-011 UPGRADE KIT PARTS LIST:

Qty -011	Part Number	Description
	DSI 9579-011	UPGRADE KIT
1	D4108-11	TEMPLATE
1	D4108-047	SILL DOUBLER ASSEMBLY
4	CR3523-4-4	RIVET
1	D3552-27	DOOR PROP

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 11.12.07

CERT. NO.: SH10-44

ISSUE NO.: 1

B	ADD DOOR PROP D3552-27	AP	11.12.07
A	NEW ISSUE	MB	11.10.14
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9579	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		UPGRADE KIT	NTS
DATE	11.12.07	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

REFERENCE ONLY

DAS
28
9-89

DART AEROSPACE LTD.

IIN-D206-802-3

Page 22 of 24

5.0 PARTS LIST

5.1 D206-802-029/-030 Crew Door Opener Kits

Qty -029	Qty -030	Part Number	Description
		D206-802-029	CREW DOOR OPENER KIT, LH
		D206-802-030	CREW DOOR OPENER KIT, RH
1	1	D3552-15	DOOR PROP
1	1	D3622-5	BALL STUD
1	1	D4110-3	DOUBLER, SILL
1		D4114-1	DOOR DOUBLER, LH
	1	D4114-2	DOOR DOUBLER, RH
4	4	MS20426AD4-5	RIVET
32	32	MS20600AD4W2	RIVET
2	2	MS21073L5	ANCHOR NUT
1	1	MS27130-A26	RIVNUT
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

5.2 D206-802-031/-032 Passenger Door Opener Kits

Qty -031	Qty -032	Part Number	Description
		D206-802-031	PASSENGER DOOR OPENER KIT, LH
		D206-802-032	PASSENGER DOOR OPENER KIT, RH
1	1	D3552-17	DOOR PROP
1	2	D3622-5	BALL STUD
	1	D4112-1	AFT SILL DOUBLER
1	1	D4115-5	DOUBLER
1		D4115-041	LITTER DOOR BRACKET ASSY
3		CR3242-5-4	RIVET
2		CR3243-5-4	RIVET
2	4	MS20426AD4-5	RIVET
9	14	MS20600AD4W2	RIVET
1	2	MS21073L5	ANCHOR NUT
3	6	NAS1149C0532R	WASHER
3	6	NAS1149C0563R	WASHER

• COPYRIGHT © 2010 BY DART AEROSPACE LTD •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: A
Date: 10.10.13